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D5189-043
Job Sheet 190078



Part No: D5189-043

Job Qty: 4 pcs

Part Name: Armrest Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No:

Due Date: 2/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 14.11.27 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	2/25/19		0.00	4.83	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
120	QC 6	4 pcs	2/25/19		0.00	0.00	QC 6 - 38		
							QC 6 - 42		
							QC 6 - 9		
							QC 6 - 68		
							QC 6 - 61		
124	Large Fab - Welded Assy-2-B4B	4 pcs	2/25/19		0.00	4.83	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
126	QC 10	4 pcs	2/25/19		0.00	0.00	QC 10 - 10		DAS 24 9-89
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 38		
							QC 10 - 43		
							QC 10 - 50		

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128 QC 5	4 pcs	2/25/19	0.00 0.00	QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
130 Powdercoat - 3 Grey Sand - B4B	4 pcs	2/25/19	0.00 0.21	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
140 QC 3	4 pcs	2/25/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
150 Packaging 3-1 - Stock - B4B	4 pcs	2/25/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 -	

DAS
24
9-89

B/L 19-02-11

SC 19/02/27

				B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	51223 " 81 MAR 06 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	4 pcs	2/25/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAG MAR 06 2019
				QC 21 - SA - 53	21

Part Op 100 - (Fabricate per Dwg), 1- Cut tube at 32.00" 2- Mark tube at 7.5" 3- Bend tube as per dwg 4- Cut ends of tube to right
 Descriptions: dimension as per dwg 5- Drill tube as per Dwg 6- Deburr
 120 - QC6- All purchased or subcontracted products
 124 - Weld per dwg A/R 4130 rod Batch: _____ WELD CAP AND FITTING AS PER DWG AND GRIND FLUSH
 126 - QC10- Inspect visual per QSI004- ground welds
 128 - QC5- Inspect part completeness to step on W/O
 130 - Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 START TIME: 12:45 OVEN TEMPERATURE: 320°
 FINISH TIME: 1:5 _____ M 138839.
 140 - QC3- Inspect Part Finish
 150 - Identify as per dwg & Stock Location: _____
 160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NT0.750W.049	4130 Round Tube .750 X.049W	12.4000 ft (3.1 ea)	100-Large Fab - Welded Assy-1	5133775
D3017-11	Cap	4 pcs (1 ea)	124-Large Fab - Welded Assy-2- B4B	5103203
D5190-1	Armrest Fitting	4 pcs (1 ea)	124-Large Fab - Welded Assy-2- B4B	5025169
D5190-3	Weld Pin	4 pcs (1 ea)	124-Large Fab - Welded Assy-2- B4B	5146055

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M4130NT0.750W.049	12	30	0
124-Large Fab - Welded Assy-2- B4B	D3017-11	4	43	0
	D5190-1	4	10	0
	D5190-3	4	16	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S151795



Part: D5189-043

Job No: 190078

Serial No/Batch: S151795

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/07/19